

Work Order ID 72193 - 2

Wednesday, July 20, 2011 7:48:03 AM

Page 1

Item ID: D3719-041

Accept

Revision ID:

Item Name: Wearplate

Start Date: 7/19/2011

Start Qty: 6.00

Required Date: 7/26/2011

Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date: 11-07-20

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3719

Rev A

100

0.00



FLOW WATER JET

0.00

Waterjet

Memo

FLOW CNC Waterjet

1-Cut as per Dwg D3719
Deburr if necessary

Dwg Rev: A

Prog Rev: A

110

0.00



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

Quality Control

120

0.00



QC8- Inspect parts - second check

0.00

QC

Memo

Quality Control

Split

RUSH

Split 4

11/07/21

11/07/21

6

6

11 07 21 6

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

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Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Large Fab

Large Fab

0.00

Memo

0.00

Large Fab

1-Weld D3009-3 cups as per dwg D3719 2-Weld hard facing as per Dwg
D3719 A/R 2059B Hard Coat rod Batch: M118196

EL 11-7-25 (X4)

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

11.07.26 (4)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11 07 26 (4)

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Required Date: 7/26/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

4 0 BL 11-7-26

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 0 BL 11/07/26

180

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/12/26 400

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/26 J

11-07-24
4

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Wednesday, July 20, 2011 7:48:09 AM

Parent Item Name: Wearplate

Required Date: 7/26/2011

Required Qty: 6.00

Comments: IPP Rev :A New Issue 07-12-19 EC verified by DD
IPP Rev:B 08-09-25 add QC5 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3009-3 		Manufactured	No			100	Each	29.0000	4	24			
Cup													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA030		29							
				42377		29							
M304S16GA 		Purchased	No			130	sf	219.4000	0.565	3.568421			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT020		19.4							
				117275		1.7							
				117653		17.7							
				MAT021		200							
				118217		200							

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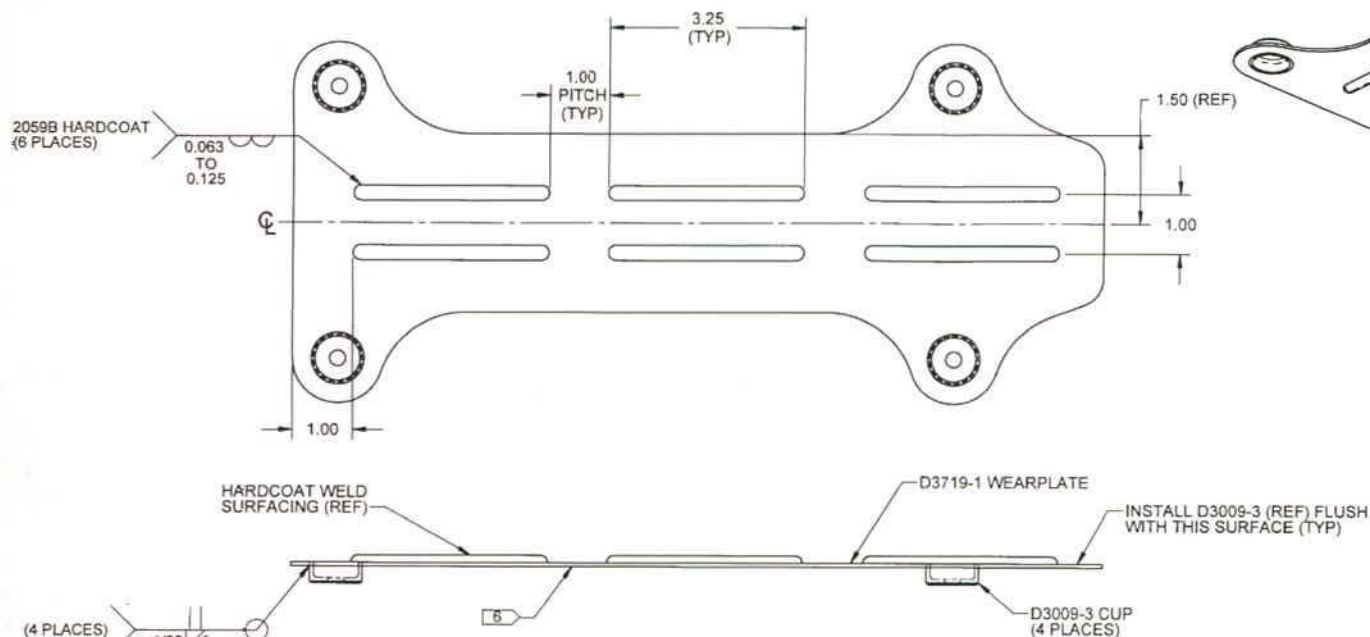
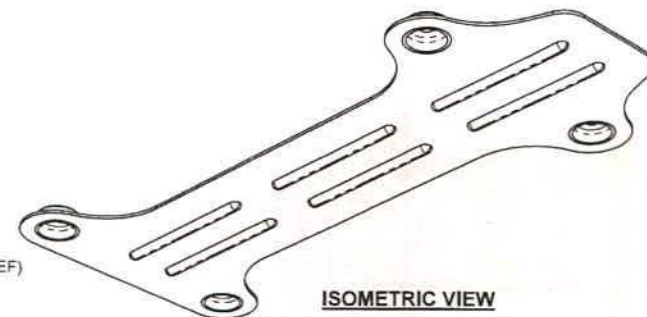
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PARTS LIST FOR D3719-041 WEARPLATE:

QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP

**D3719-041 WEARPLATE****ISOMETRIC VIEW**

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72193

2/11-07-20

RELEASED
07-01-07 JML

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4,3,5,6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WELD PER DART QSI 004

A	NEW ISSUE		CP	07.12.12
REV.		DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3719 TITLE WEARPLATE		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>			
MFG. APPR.	<i>[Signature]</i>			REV. A
APPROVED	<i>[Signature]</i>			SHEET 1 OF 2
DE APPR.	<i>[Signature]</i>			SCALE
DATE	07.12.12			12
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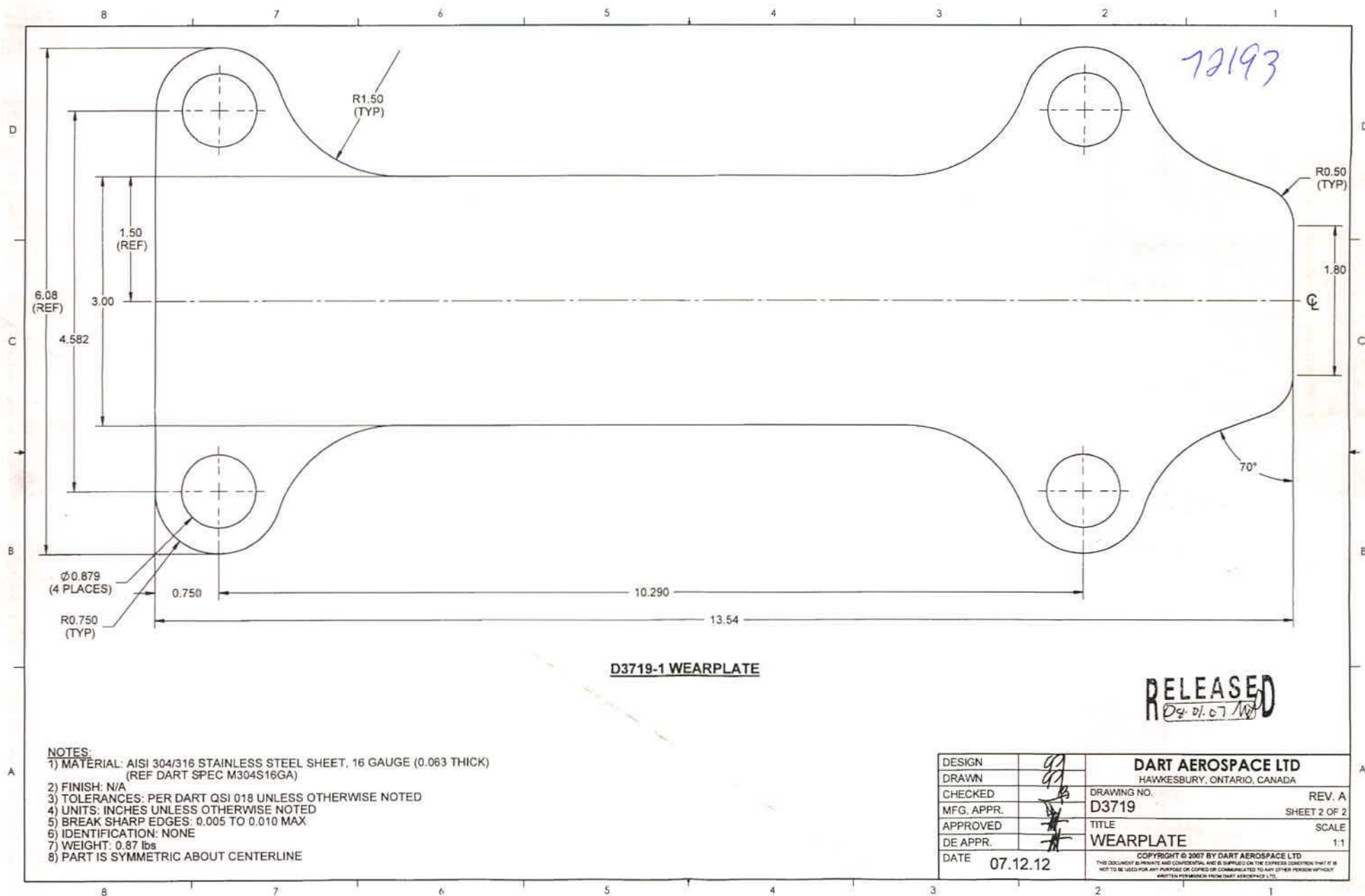
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